

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER		
Job Number	: 32692				
Estimate Number	: 11167				
P.O. Number	: <i>N/A</i>	Part Number	: D32783		
This Issue	: 5/25/2007	S.O. No.	: <i>N/A</i>	Drawing Number	: D3278 REV B
Prsht Rev.	: NC			Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i>	Type	: SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31941			Material	: <i>N/A</i>
Written By	: <u><i>[Signature]</i></u>	Due Date	: 6/1/2007	Qty:	40 Um: Each
Checked & Approved By	: <u><i>[Signature]</i></u>				
Comment	: Est. A 04.04.19 New issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRINS0125X300	Black Delrin
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Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.4448 sf(s)

Black Delrin

Use DT8685 Router Table.

Material: Black Delrin/UHMW 0.125" thick

(M-DELRIN-S0.125x30.0)

Identify for D3278-3

Batch: M15607

07/06/06

4

20	WATER JET	FLOW WATER JET
----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev: 13

Prog Rev: β

2-Deburr if necessary

577

07/06/08

cl

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

0 Ad-

07/06/06

9.

40 QC8 SECOND CHECK



Comment: SECOND CHECK

SECOND CHECK



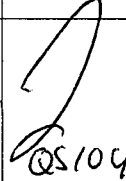

07.06.07 41 counted

07.06.07 41 counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/06	Z. V	machine 4 part scrap machine mal function. holes to large, drive to get offset.	 QS1042	Scrap - destroy/replac (41) new on W/O	SAN 07/06/06	 0706-06	 QS1042	 070606

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 12:40:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 32692

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-C'sink as per dwg D3278

*Notes: c'sink on the wider side of the hole. (x4)

2-Deburr

ml 07/06/11

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/11 (41)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

5789

GA ml 07/06/11 - x28
store

PTO
- x12 07/06/11

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

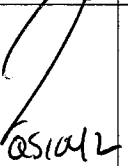



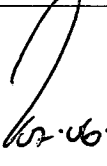


U 07-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/11	7	Scrap one part when install rivet	 05/06/12	Scrap and not replace	 07/06/11	 07-06-12	 05/06/12	 07-06-12

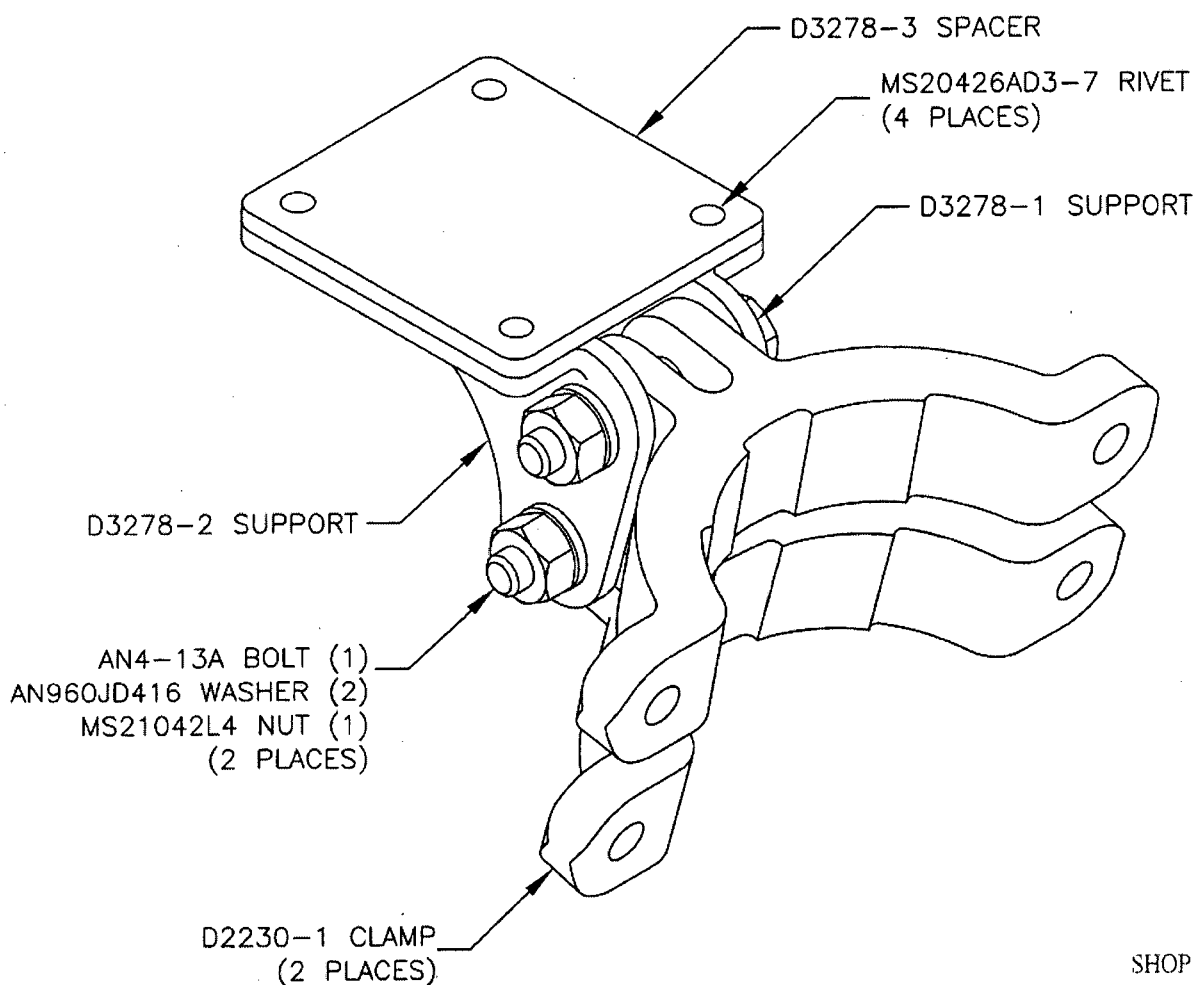
NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE	05.03.31			TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04

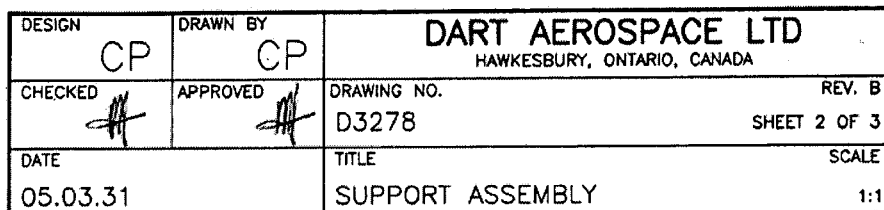
D3278-041 SUPPORT ASSEMBLY



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05.04.04

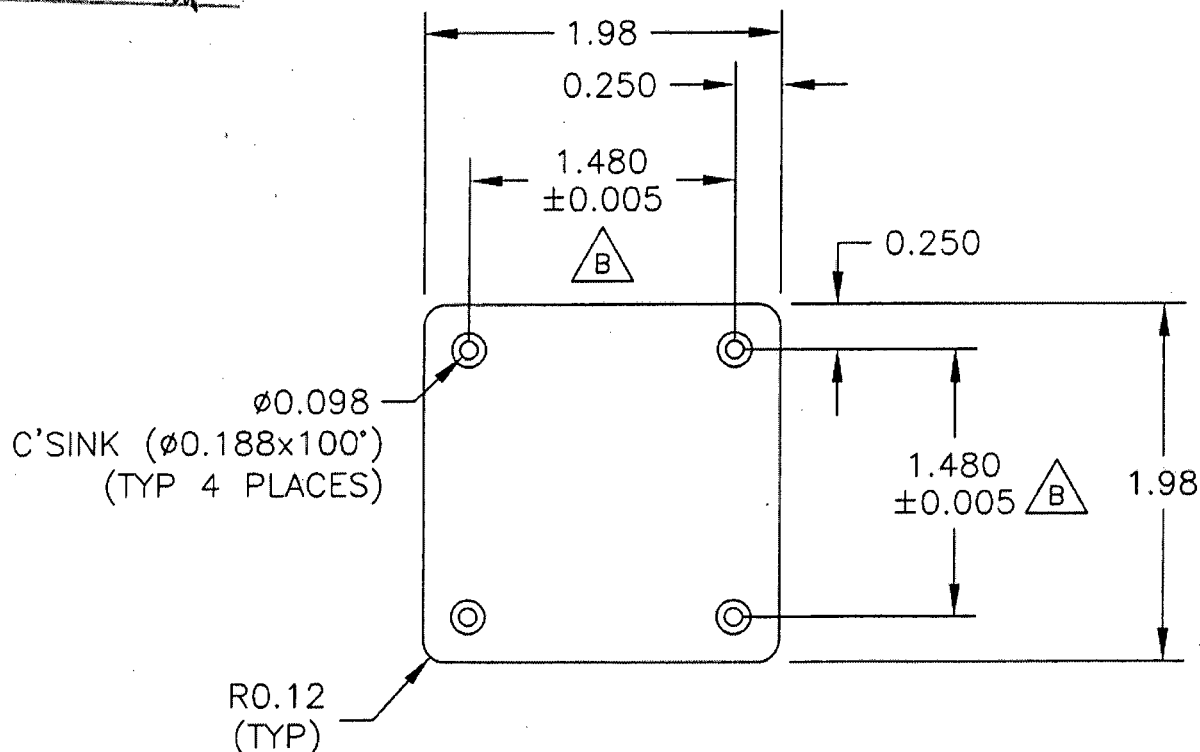


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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
05.04.04 *[Signature]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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